

PATENT ABSTRACTS OF JAPAN

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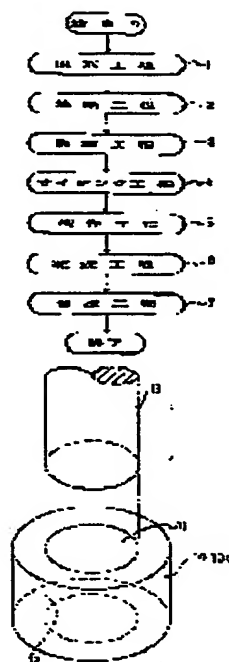
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(54) METHOD FOR MANUFACTURING SINTERED COMPONENT

(57)Abstract:

PROBLEM TO BE SOLVED: To manufacture sintered components having a high quality under a low cost by a method wherein hydro-carbon oil is applied to any one of rust-proof liquid, sizing lubricant and cleaning liquid used in a manufacturing stage.

SOLUTION: A cylindrical pressed powder member 10a is attained at a mold forming step 1 and a sintered body 10 is attained at a sintering step 2. The sintered body 10 is immersed into hydrocarbon oil acting as rust-proof liquid so as not to cause rust to be generated at the surface of the sintered body 10 at the rust-proof step 3. A sizing rod 13 is moved up and down within a hole 11 of the sintered body 10 at a sizing step 4 and then porous part or burrs at the inner circumferential surface 12 of the sintered body 10 are compressed again. The rust-proof liquid is utilized as sizing lubricant liquid. At a cleaning step 5, hydrocarbon oil which is the same as the rust-proof liquid is used as the cleaning liquid and then metallic chips generated on the porous portions of the sintered body 10 or generated during sizing operation are removed rather than removing the rust-proof liquid. The sintered body 10 is heated at a drying step 6 so as to evaporate cleaning liquid. Since the hydrocarbon oil has a superior drying characteristic, it is completely evaporated and even if the oil is left as a completed product as it is, no cleaning liquid is left, so that a sintered component having a high quality can be attained.



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